

PCT

CORR. US 5,936,027
WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : D06P 1/00, 5/00, 1/52, C09D 11/00		A1	(11) International Publication Number: WO 95/29287
			(43) International Publication Date: 2 November 1995 (02.11.95)
(21) International Application Number: PCT/GB95/00951		(81) Designated States: AM, AT, AU, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LT, LU, LV, MD, MG, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TT, UA, UG, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG), ARIPO patent (KE, MW, SD, SZ, UG).	
(22) International Filing Date: 25 April 1995 (25.04.95)			
(30) Priority Data: 08/232,730 25 April 1994 (25.04.94) US			
(71) Applicant: THE GENERAL ELECTRIC COMPANY, PLC [GB/GB]; 1 Stanhope Gate, London W1A 1EH (GB).			
(72) Inventors: ZAHROBSKY, Peter, Carlson; 336 May Avenue, Glen Ellyn, IL 60137 (US). LENT, Bruce, Alan; 600 North Ridgeland, Oak Park, IL 60302 (US).			
(74) Agent: McGOWAN, Nigel, George; GEC Patent Department, Waterhouse Lane, Chelmsford, Essex CM1 2QX (GB).			
(54) Title: AN INK COMPOSITION FOR USE WITH TEXTILES			
(57) Abstract A jet ink composition for use with textiles which comprises a pigment dispersed with an ethyl cellulose resin, a silicone resin, a phenolic resin, and at least one non-aqueous solvent in which the pigment dispersion, silicone resin, and phenolic resin are dissolved. The printed images formed therefrom are readable even when applied to darkly-dyed textiles.			

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	GB	United Kingdom	MR	Mauritania
AU	Australia	GE	Georgia	MW	Malawi
BB	Barbados	GN	Guinea	NE	Niger
BE	Belgium	GR	Greece	NL	Netherlands
BF	Burkina Faso	HU	Hungary	NO	Norway
BG	Bulgaria	IE	Ireland	NZ	New Zealand
BJ	Benin	IT	Italy	PL	Poland
BR	Brazil	JP	Japan	PT	Portugal
BY	Belarus	KE	Kenya	RO	Romania
CA	Canada	KG	Kyrgyzstan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SI	Slovenia
CI	Côte d'Ivoire	LI	Liechtenstein	SK	Slovakia
CM	Cameroon	LK	Sri Lanka	SN	Senegal
CN	China	LU	Luxembourg	TD	Chad
CS	Czechoslovakia	LV	Latvia	TG	Togo
CZ	Czech Republic	MC	Monaco	TJ	Tajikistan
DE	Germany	MD	Republic of Moldova	TT	Trinidad and Tobago
DK	Denmark	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	US	United States of America
FI	Finland	MN	Mongolia	UZ	Uzbekistan
FR	France			VN	Viet Nam
GA	Gabon				

AN INK COMPOSITION FOR USE WITH TEXTILES

5 This invention relates to ink-jet printing, and particularly relates to a new ink jet ink composition for use in textile applications.

Marking methods such as roller printing, screen printing, transfer printing, and stitching or sewing of messages have been used for marking textiles such as woven fabrics, non-woven fabrics, and blended woolen fabrics. However, these conventional methods are expensive and slow, because they require special preparation of the fabric and/or additional manufacturing steps. Therefore, these methods are not economical.

15 The use of ink jet printing has been proposed as a more economical and flexible method. Because ink jet printing could be done while the textile is on the production line, it would not slow the production process.

20 Ink jet printing is a well-known technique by which printing is accomplished without contact between the printing device and the substrate on which the printed characters are deposited. Briefly described, ink jet printing involves the technique of projecting a stream of ink droplets to a surface and controlling the flight of the droplets electronically so that they are directed to form the desired printed image on that surface. This technique of non-contact printing is particularly well suited for application of characters onto irregularly shaped surfaces, including, for example, the curved bottom of beverage containers.

30 In general, an ink jet composition must meet certain rigid requirements to be useful in ink jet printing operations. These relate to viscosity, resistivity, solubility, compatibility of components and wettability of the substrate. Further, the ink must be quick-drying

5 and smear resistant, must be capable of passing through the ink jet nozzle without clogging, and must permit rapid clean-up of the machine components with minimum effort.

10 Ink jet printing, however, also has several drawbacks. The quality of the print tends to be impaired due to blotting on the cloth, partly because the ink jet printer does not allow the use of an ink having high viscosity and partly because cloth usually has a more uneven texture than paper, thus making it difficult to
15 print patterns of minute or delicate design. This blotting, or spreading, also to date made ink jet printing unsuitable for use in dyed textiles, because when the ink spreads its contrast with the dyed textile is diminished.

20 In addition, discharge of the ink tends to be unstable, and the response to high frequency is liable to be impaired depending on the physical property of the ink, owing to the fact that the ink has to be discharged through minute nozzles at high velocity and high
25 frequency. Further, print formed from using a conventional ink jet formulation exhibits a slow dye-fixing rate and minimal washing fastness.

Certain ink jet formulations and methods of using them have been proposed to eliminate these problems.
30 U.S. Patent No. 4,702,742 relates to a method of applying an aqueous dye containing an ink on cloth that has been previously treated with an ink acceptor. The ink is then optionally subjected to a dye-fixing treatment.

U.S. Patent No. 4,725,849 discloses a process of ink
35 jet printing comprising applying an aqueous dye-containing ink to a cloth that has been pre-treated with an ink receiving material having a viscosity of 1000 centipoises. The ink receiving material may be a water soluble resin-containing solution or a hydrophilic resin-containing solution.
40

5 U.S. Patent No. 4,849,770 relates to an ink jet
formulation comprising a reactive dye or reactive
dispersing dye, and a solvent composed mainly of water
and an organic solvent non-reactive with the dye. This
10 formulation is applied via ink jet printing to a textile,
and is then subjected to a dye-fixing treatment.

U.S. Patent No. 4,969,951 discloses an ink jet
formulation comprising a reactive disperse dye and a
solvent composed of water, or water and a water-soluble
organic solvent. This formulation is applied via ink-jet
15 printing to a textile, and is then subjected to a dye-
fixing treatment.

Japanese Patent No. 62225577 relates to an ink jet
composition for textile printing operations comprising a
pigment, a water-soluble or aqueous dispersible polyester
20 or polyamide, a cross-linking agent, and water.

Japanese Patent No. 61213273 discloses an ink jet
composition for use with polyester fibers comprising a
water-insoluble pigment, dispersant consisting of a 3:1
ratio of aromatic rings to sulfonate or sulphuric ester
25 group.

Japanese Patent No. 62231787 relates to a method of
textile printing using an ink jet composition comprising
a pigment and a water-soluble or dispersable polyester or
polyamide. The textile to be printed is first treated
30 with a metal salt or cationic compound. The ink is then
applied, and is cross-linked by a cross-linking agent
present either in the ink or on the textile.

Japanese Patent No. 2189373 discloses an ink jet
composition for textile printing operations comprising
35 water-insoluble pigment having particles with a diameter
of 0.03-1.0 microns, and a dispersion media, wherein the
solution density is 1.010-1.300.

The aforementioned ink compositions and methods of
using them also suffer from several drawbacks. First, in
40 some instances it is necessary to pre-treat the textile
prior to application of the ink to prevent spreading or

5 blotting. Other of the above-noted patents require
chemical fixing treatments after the ink has been
applied. Further, all of the aforementioned ink
formulations and methods relate to dark-colored inks for
10 use on white or light colored textiles. These inks are
not visible if the textile is a dark color, such as navy
blue, maroon, or black.

Therefore to date, there has been no white or
pastel-colored ink formulation for ink jet printing on
textiles. There exists a need for such inks in the
15 industry. Currently, fabrics are coded with brand names,
sizes, or color information by stitching or contact
printing. This step is inefficient, however, because it
slows down production.

According to the present invention there is provided
20 an ink composition for use with textiles, comprising a
pigment, a resin selected from the group consisting of
acrylic resin, vinyl resin, modified rosin ester and an
ethyl cellulose resin, a silicone resin, a phenolic
resin, and at least one non-aqueous solvent.

25 The present invention overcomes the problems
associated with prior art ink compositions for ink jet
printing on dark colored textiles, and achieves distinct
advantages thereover. The ink compositions of the
present invention contain hydrophobic components and,
30 therefore, resist being drawn into water-dampened textile
substrates. In accordance with one aspect of the present
invention, an ink jet ink composition is provided
comprising a pigment dispersed with an ethyl cellulose
resin, a silicone resin, a phenolic resin, and a non-
35 aqueous solvent. It is now possible to formulate ink jet
ink compositions for printing on textiles that have good
adherence to a variety of textiles.

The ink compositions of the present invention may
also comprise, and preferably do comprise, in addition to

5 the four components mentioned above, a dispersing agent, a plasticizer, and an electrolyte.

A detailed description of the preferred embodiments will now be given.

Pigment

10 The pigment used in the present invention should have a color that contrasts with the substrate to which it is to be applied. The maximum particle size of the pigment should also be less than about 1 micron in diameter. The preferred pigment for use in the inks of
15 the present invention is titanium dioxide.

In order to obtain pigment particles of useful size for incorporation into an ink jet ink, pigment is ground with a non-reactive binder resin which separates pigment particles and prevents them from coalescing via
20 electrostatic interaction. The resultant solid/solid dispersion, referred to as pigment "chip", maintains pigment particle size until the pigment is ready to be incorporated into the ink. The ratio of pigment to binder resin in the supplied chip is usually about 1:1 to
25 9:1, with a preferred ratio of about 75% pigment to 25% binder resin by weight of the chip. Useful binder resins for the current invention include acrylic, vinyl, modified rosin ester, or ethyl cellulose. Useful pigments include organic pigments, aluminum silicate, or
30 titanium dioxide. The preferred chip in the ink of current invention contains titanium dioxide pigment and ethyl cellulose binder resin. This chip is available under the trade name Microlith White R-A, from Ciba-Geigy Corporation.

35 During formulation of the ink composition of the present invention, chip binder resin is dissolved by the ink solvent. The pigment is preferably kept from agglomeration by a dispersing agent. It is believed that the dispersing agent chemically binds with pigment
40 particles creating a steric shield around each particle

5 and stabilizing the solid/liquid dispersion of the ink. The dissolved binder resin, along with each of the other resins added, aids in maintaining the solid/liquid ink dispersion by increasing bulk solution viscosity which, in turn, reduces particle settling.

10 The pigment typically is present in an amount from about 4% to about 15% by weight of the ink composition. Preferably, from about 4% to about 8% of pigment by weight of the ink composition should be present.

Silicone Resin

15 The silicone resin binds the pigment to the substrate, disperses the pigment, and prevents the ink composition from spreading on the substrate, especially if the textile has been pretreated with water. It is dissolved in the ink composition. The preferred silicone
20 resin is diphenyl, methyl, phenyl, phenyl methyl silicone, available under the trade name DC6-2230 from Dow Corning.

The silicone resin typically is present in an amount from about 3% to about 20% by weight of the ink
25 composition, with from about 3% to about 7% by weight being preferred.

Phenolic Resin

The phenolic resin also binds the pigment to the substrate, disperses the pigment, and prevents the ink
30 composition from spreading on the substrate, especially if the textile has been pretreated with water. The phenolic resin also imparts laundering resistance to the printed message or code. It is dissolved in the ink. Phenolic resins useful in the ink compositions of the
35 present invention include phenol-formaldehydes, bisphenol A phenol-formaldehydes, and butylated phenol-formaldehydes. The preferred phenolic resin is a bisphenol A phenol-formaldehyde, available under the trade name Varcum 29-108, from Occidental Chemical Co.

40 The phenolic resin typically is present in an amount from about 1% to about 20% by weight of the ink

5 composition, with from about 1% to about 4% by weight being preferred.

Solvent

10 The solvent dissolves and/or suspends the ink components, and keeps the ink composition in a fluid state so that the ink will flow readily through the head of the ink jet printing device. Solvents useful in the ink compositions of the present invention include alcohols and ketones, which may be used alone or in admixture. Particularly useful are ethanols denatured with isopropanol and n-propyl acetate, and methyl isobutyl ketone. The preferred denatured ethanol is available as Duplicating Fluid 100C.NPA from Petro Products. The solvent system should be non-aqueous, that is, containing not more than about 5% water.

20 The solvent typically is present in an amount from about 40% to about 95% by weight of the ink composition, with an amount from about 60% to about 80% by weight being preferred.

Other Components

25 An electrolyte can also be used in the ink compositions of the present invention to ensure that the ink composition has suitable electrical conductivity, especially if the ink is to be used in continuous ink jet printing. The electrolyte is usually potassium thiocyanate or an inorganic salt such as lithium nitrate. The electrolyte usually is present in an amount up to about 3% by weight of the ink composition, with an amount up to about 1.5% being preferred.

35 Dispersing agents can be present in the ink composition of the present invention to prevent agglomeration of pigment particles, such as titanium dioxide particles in the ink. Preferred dispersing agents are Disperbyk 163, available from BYK Chemie USA, BYK-P-104S (a high molecular weight unsaturated polycarboxylic acid/polysiloxane copolymer solution), available from BYK Chemie USA, Anti-Terra-U, also

40

5 available from BYK Chemie USA, and Nopcosperse, available from Henkel Corp., are also useful. The dispersing agent usually is present in an amount up to about 1.5% by weight of the ink composition, with an amount up to about 0.5% being preferred.

10 Further, a plasticizer, such as Santicizer 8 (N-ethyl-o,p -Toluenesulfonamide), available from Monsanto, may be used to soften the resin component of the ink, so that the ink does not "flake off" the substrate after application. The plasticizer usually is present in an
15 amount up to about 3% by weight of the ink composition, with an amount up to about 1.5% being preferred.

The present invention may also comprise other additives, which may be any substance that can enhance the ink composition with regard to (a) improved
20 solubility of other components, (b) improved adhesion of the ink to the substrate, (c) improved print quality, and (d) control of wetting characteristics, which may be related to such properties as surface tension and viscosity, among other properties.

25 For example, antioxidants and/or UV light stabilizers can be used in combination or separately. Useful antioxidants include hindered phenols, such as BHT, TBHQ, and BHA, which are sold under the trade names Tenox (Eastman Chemical Products), Ethanox (Ethyl Corp.),
30 and Irgazox (Ciba-Geigy). Light stabilizers for ultraviolet and visible light include hindered amines such as Tinuvin 770, 765, and 622, and substituted benzotrioles such as Tinuvin P326, 327, and 328, all of which are available from Ciba-Geigy. Also, substituted
35 benzophenones Cyasorb UV-531, UV-24, and UV-9, available from American Cyanamid Co. can be used.

General Considerations

The viscosity of the ink compositions of the present invention is generally from about 2 to about 8
40 centipoises, and preferably is from about 4.0 to about 5.5 centipoises. The viscosity of a given ink

5 composition can be adjusted depending on the specific components used therein, and such adjustment is with the skill of those in the art.

Printed images may be generated with the ink compositions of the present invention by incorporating
10 the inks into a continuous or drop-on-demand ink jet printer, and causing droplets of the ink to be ejected in an imagewise pattern onto a substrates such as textiles. Suitable printers for employing the ink compositions of the present invention include commercially available ink
15 jet printers.

The formulated jet inks of the present invention will exhibit the following characteristics: (1) a viscosity from about 2 to about 8 centipoises (cps) at 25°C, (2) an electrical resistivity from about 50 to
20 about 2,000 ohms-cm⁻¹, (3) a sonic velocity from about 1,200 to about 2,000 m/sec., (4) a surface tension below 28 dynes/cm, (5) a pH in the range of from about 3 to about 9, and (6) a specific gravity from about 0.8 to about 1.1.

25 The ink compositions of this invention can be applied to a wide range of dark colored textiles. However, the invention is of special use in forming images on dark colored nylon, cotton, acrylic, or wool textiles.

30 When the ink compositions of the present invention are applied to dark colored textiles, the image formed by the ink will not spread and will be easily visible. The print color contrast of the ink with dark colored textile can be enhanced by pre-treating the textile with water.
35 Post-treating the printed textile with either dry or steam heat is necessary to "fix" the print, making it resistant to laundering.

The present invention is further illustrated by the following example.
40

5

Example

	<u>Material</u>	<u>% By Weight</u>
	Duplicating Fluid 100 C.NPA	69.9
	DC 6-2230 Silicone Resin	5.3
10	Methyl Isobutyl Ketone	12.7
	Varcum 29-108	2.6
	Disperbyk 163	0.5
	Microlith White R-A	7.5
	Saniticzer 8	0.5
15	Potassium Thiocyanate	<u>1.0</u>
		100.0

20 An ink containing the above components was formulated as follows:

25 The silicone resin was added to approximately one-fourth (1/4) of the total Duplicating Fluid 100C.NPA to be used. All of the methyl isobutyl ketone was then added. Varcum 29-108 was next added, followed by Disperbyk 163 dispersing agent, followed by the Microlith White R-A chip, followed by the addition of Saniticzer 8. After each addition, the solution was mixed until the added component was dissolved or dispersed. After the Saniticzer 8 was added, the solution was mixed at high speed, using a dispersion blade, for 60 minutes. The remainder of the Duplicating Fluid 100C.NPA was then added, followed by the potassium thiocyanate. Again, the ink was mixed after each addition. After addition of the potassium thiocyanate, the ink was filtered and bottled.

35 The ink made according to the above procedure had a viscosity of 4.8 centipoises, a resistivity of 850 ohms-cm, a specific gravity of 1.0, a pH of 7.4, and a surface tension of 23.4 dynes/cm. The ink was then used to print a message on black nylon, cotton & acrylic socks. The resulting message was white, and exhibited excellent color contrast and stability.

40

5 CLAIMS:

1. An ink composition for use with textiles, comprising a pigment, a resin selected from the group consisting of acrylic resin, vinyl resin, modified rosin ester and an ethyl cellulose resin, a silicone resin, a phenolic resin, and at least one non-aqueous solvent.

2. An ink composition for use with textiles, where such ink composition is formulated from at least the following components:

- 15 (a) a pigment dispersed with a resin selected from the group consisting of acrylic resin, vinyl resin, modified rosin ester and an ethyl cellulose resin;
- (b) a silicone resin;
- (c) a phenolic resin; and
- 20 (d) at least one non-aqueous solvent.

3. An ink composition for use with textiles comprising a pigment dispersed with a resin selected from the group consisting of acrylic resin, vinyl resin, modified rosin ester and an ethyl cellulose resin, a silicone resin, a phenolic resin, and at least one non-aqueous solvent.

4. An ink composition as claimed in any one of Claims 1 to 3, wherein the pigment is titanium dioxide.

5. An ink composition as claimed in claim 4, wherein the titanium dioxide is present in an amount from about 4% to about 15% by weight of said ink composition.

6. An ink composition as claimed in any one of the preceding claims, wherein the silicone resin is present in an amount from about 3% to about 20% by weight of such ink composition.

5 7. An ink composition as claimed in any one of the preceding claims, wherein the phenolic resin is present in an amount from about 1% to about 20% by weight of such ink composition.

10 8. An ink composition as claimed in any one of the preceding claims, additionally comprising a dispersing agent.

15 9. An ink composition as claimed in claim 8, additionally comprising a plasticizer.

 10. An ink composition as claimed in claim 9, additionally comprising an electrolyte.

20 11. An ink composition for use in ink jet printing of textiles, comprising titanium dioxide dispersed with an ethyl cellulose resin, a silicone resin, a phenolic resin, a dispersing agent, an electrolyte, and a plasticizer, and at least one non-aqueous solvent,
25 wherein the weight ratio of ethyl cellulose resin to titanium dioxide is approximately 1:3 and the titanium dioxide is present in an amount from about 4% to about 15% by weight of said ink composition, said silicone resin is present in an amount from about 3% to about 20%
30 by weight of said ink composition, said dispersing agent is present in amount less than about 1.5% by weight of said ink composition, said electrolyte is present in an amount less than about 3.0% by weight of said ink composition, said plasticizer is present in an amount
35 less than 3.0% by weight of said ink composition, and said non-aqueous solvent is present in an amount from about 40% to about 95% by weight of such ink composition.

40 12. An ink composition as claimed in any one of the preceding claims, wherein the silicone resin is diphenyl, methyl, phenyl, phenyl methyl silicone.

5 13. An ink composition as claimed in any one of the preceding claims, wherein the solvent is selected from the group consisting of alcohols and ketones.

10 14. An ink composition as claimed in any one of the preceding claims, wherein the phenolic resin is bisphenol A phenol-formaldehyde.

15 15. An ink composition as claimed in claim 10 or 11, wherein said electrolyte is potassium thiocyanate.

20 16. A method for using ink jet printing to obtain a visible printed image on a dyed textile comprising: jetting onto said textile an ink as claimed in any one of the preceding claims.

25 17. A method for using ink jet printing to obtain a visible printed image on a textile comprising:

- (a) treating said textile with water;
- (b) jetting onto said textile an ink as claimed in any one of claims 1 to 15; and
- (c) applying heat to said textile.

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 D06P1/00 D06P5/00 D06P1/52 C09D11/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 D06P C09D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,A	EP-A-0 604 105 (CANON KK) 29 June 1994 see page 4, line 45 - page 5, line 34; claims	1-17
A	US-A-4 689 049 (BURKE EUGENE ET AL) 25 August 1987 see claims	1-15
A	GB-A-2 088 402 (DAINIPPON TORYO KK) 9 June 1982 see page 1, line 5 - line 8 see page 3, line 25 - line 33; claims	1-15
	--- -/--	

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *Z* document member of the same patent family

Date of the actual completion of the international search

31 August 1995

Date of mailing of the international search report

05.09.95

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+ 31-70) 340-2040, Tx. 31 651 epo nl,
Fax (+ 31-70) 340-3016

Authorized officer

Blas, V

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DATABASE WPI Section Ch, Week 8222 Derwent Publications Ltd., London, GB; Class A23, AN 82-45491E & SU-A-852 982 (KIEV BR SPEC PRINT) , 7 September 1981 see abstract ---	1-17
P,A	PATENT ABSTRACTS OF JAPAN vol. 018 no. 430 (C-1236) ,11 August 1994 & JP,A,06 128513 (DAINIPPON TORYO CO LTD) 10 May 1994, see abstract ---	1-15
A	EP,A,0 071 345 (AMERICAN CAN COMPANY) 9 February 1983 see the whole document -----	1-15

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP-A-0604105	29-06-94	JP-A- 6184956 CN-A- 1093132	05-07-94 05-10-94
US-A-4689049	25-08-87	NONE	
GB-A-2088402	09-06-82	JP-C- 1257112 JP-A- 57090068 JP-B- 59028591 DE-A- 3120534 US-A- 4338133	29-03-85 04-06-82 13-07-84 09-06-82 06-07-82
EP-A-71345	09-02-83	AU-B- 557713 AU-A- 8631282 CA-A- 1186143 JP-C- 1621936 JP-B- 2047510 JP-A- 58032674	08-01-87 27-01-83 30-04-85 09-10-91 19-10-90 25-02-83